

Date: Wednesday, 7/19/2006 2:07:08 PM
User: Kim Johnston

Process Sheet

| | | | |
|--|---------------------|--|-----------|
| DART TRANSPORT CANADA APPROVAL # 09-89 | | TEL: 1-613-632-3336 FAX: 1-613-632-4443 | |
| P/N | D206-667-103 | Q16 | CHG002 |
| DESC | Crosstube Fwd High | STC | SH01-5 |
| LOT | B25606 | STC | SR01304NY |
| MODEL | Bell 206L1/L1/L3/L4 | STC | |
| MADE IN CANADA | | | |

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 27980

Estimate Number : 12376

P.O. Number : N/A

This Issue : 7/19/2006 S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A Type : LANDING GEAR

Previous Run : N/A

Written By : See Comment Below

Checked & Approved By : 06.07.19

Comment : Est Rev:A New Issue 06-04-19 JLM

Drawing No:

Part Number : D206667103A

Drawing Number : DSI9326

Project Number : N/A

Drawing Revision : A

Material : N/A

Due Date : 7/26/2006

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: Photocopy bluefilé & type labels per PPPD206-667-103A CHG001
Add DSI 9326 to existing paper work.

RS 06.07.19 (1)

2.0

D206667103

Crosstube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Fwd Crosstube

Batch: B25606

06.07.22 (1)

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Remove tube from packaging

2-Apply Armor shield as per DSI 9326

A/R Armor Shield Batch: M101241

06.07.22 (1)

4.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

06.07.24 (1)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103A

Location:

PPP Rev: DRAFT

06/2/25 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/07/25

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 7/19/2006 2:07:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMOR SHIELD

Job Number: 27980

Part Number: D206667103A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/07/25 (1)

Job Completion



AJ 06.07.25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | |
|-------------------------|-----------------------|--|------------------------|
| DESIGN <i>PH</i> | DRAWN BY <i>PH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>J. J.</i> | APPROVED <i>A</i> | DRAWING NO. DSI 9326 | REV. A SHEET 1 OF 1 |
| DATE 06.02.14 | | TITLE ARMOR SHIELD | SCALE NTS |
| A | 06.02.14 | NEW ISSUE | |

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

| INSTALLATION | CANADIAN STC | FAA STC |
|-----------------------------|--------------|-----------|
| D205-596-101/-103/-105/-107 | SH03-6 | SR01742NY |
| D212-664-101/-201 | SH01-9 | SR01298NY |
| D412-664-203 | | |
| D206-667-101/-103/-201/-203 | SH01-5 | SR01304NY |
| D407-667-105/-205 | | |
| D058-676-101/-201 | N/A | SR01018SE |

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface (apply additional coats when surface is dry, but not fully cured)
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.

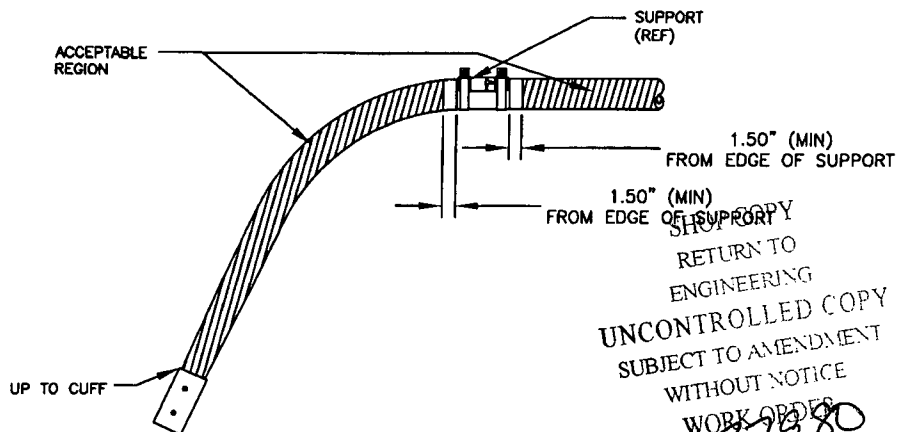


FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD

| | |
|--|-----------------------|
| CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01 | |
| APPROVED | |
| BY: <i>D. Shepherd</i> | D. SHEPHERD (DE # 02) |
| DATE: 06.02.14 | |
| CERT. NO.: SH03-6/SH01-9/SH01-5 | |
| ISSUE NO.: 3/3/3 | |

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